

Work Order ID 53639-1

November 11, 2009 11:42:17 AM



SPLIT-1

Page 1

Item ID: D3511-041

Accept



Setup Start



Revision ID: A

Item Name: Wearplate Assembly

Stop



Start Date: 11/11/2009 Start Qty: 8.00

Cust Item ID:

Required Date: 11/20/2009 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-11-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3511	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3511 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
Deburr if necessary ☐ Identify as D3511-1

IB 9-11-17

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IB 9-11-17

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) S 02/11/18

416 f

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 53639

November 11, 2009 11:42:17 AM



Page 2

Item ID: D3511-041  
 Revision ID: A  
 Item Name: Wearplate Assembly  
 Start Date: 11/11/2009 Start Qty: 8.00  
 Required Date: 11/20/2009 Req'd Qty: 8.00  
 Reference:

Accept



Setup Start



Stop



Cust Item ID:  
 Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	Small Fab  Memo Bend fwd 90 deg. per dwg D3511	0.00  0.00	Sp 09/4/18			16	8		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				(16)	f		
150  Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch: <u>M108775</u> Large Fab  Memo weld cups as per dwg	0.00  0.00	Sp 09/11.19.						(15x)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 53639**

November 11, 2009 11:42:17 AM



Page 3

Item ID: D3511-041

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Setup Start



Revision ID: A

Stop



Item Name: Wearplate Assembly

Start Date: 11/11/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 11/20/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Small Fab

Small Fab

0.00

Memo

0.00

SB 09/11/20

5 6

Small Fab

Form as per Dwg D3511

170



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

\*

PD 09.11.23 (5)

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

→ S 09/11/23

(45) 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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November 11, 2009 11:42:17 AM



Page 4

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Revision ID: A  
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Setup Start



Stop



Start Date: 11/11/2009 Start Qty: 8.00  
Required Date: 11/20/2009 Req'd Qty: 8.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo START TIME: 8:45 FINISH TIME: 9:15	0.00  0.00							
200  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
210  Packaging Packaging	Identify as per dwg & Stock Location: 446A  Memo	0.00  0.00							

RR 09-11-24. (S)

7 m. k 09/11/24 (SX)

6/24/25 (S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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November 11, 2009 11:42:17 AM



Page 5

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Stop



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Start Date: 11/11/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 11/20/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/20 11:42

R 09-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

November 11, 2009 11:42:16 AM

Page 1

Work Order ID: 53639

Parent Item: D3511-041RevA

Parent Item Name: Wearplate Assembly



Comments: IPP Rev:B New process 06-05-05 EC

Start Date: 11/11/2009

Required Date: 11/20/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3503-1RevA  Cup		Manufactured	No			150	Each	27.0000	64.0000			

Sp 09.11.19.

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	53617	
ST	27	
47971	27	

40X

M304S188



304 SHEET 0.188

Purchased No

100 sf

11.5000 12.4968



30 LX

HB 9-11-17

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	11.5	
107676	8.5	
107875	3	

113161

113161

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

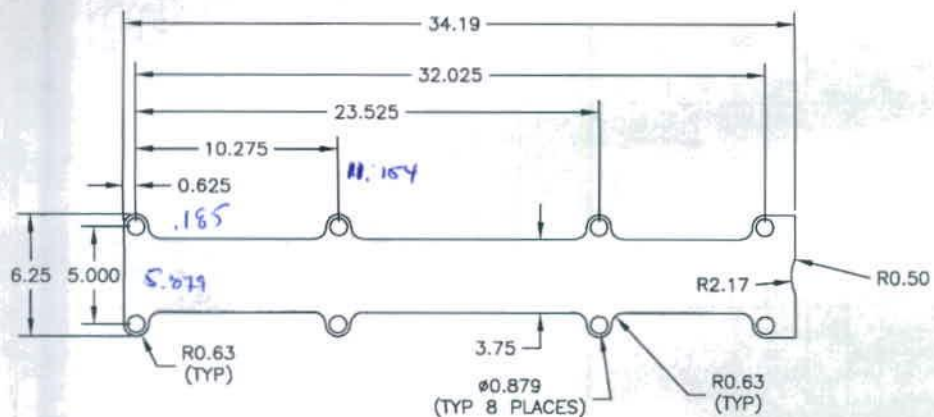
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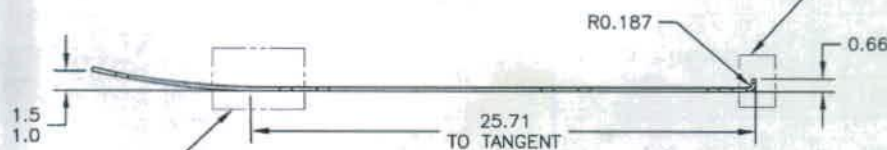


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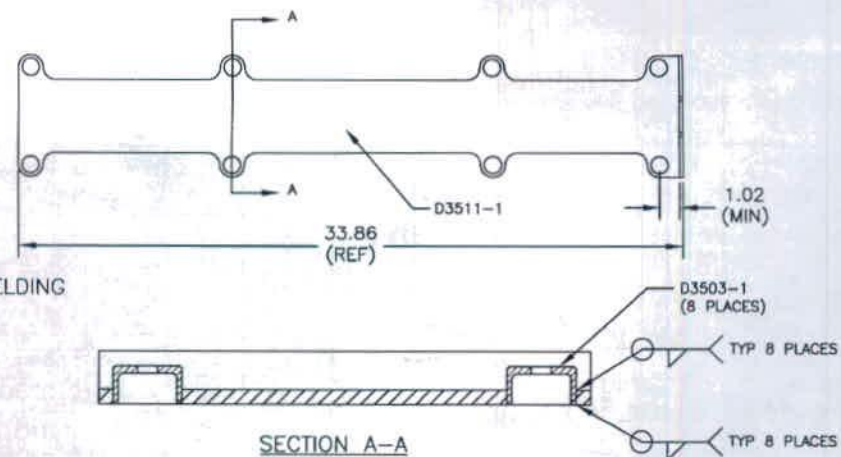
**D3511-1F FLAT PATTERN**

NOTE: BEND BEFORE WELDING



**D3511-1 BEND DETAIL**

NOTE: BEND AFTER WELDING



**D3511-041 WELD DETAIL**

**D3511-041 WEARPLATE ASSEMBLY**

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)  
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3511-041 WEARPLATE ASSEMBLY PARTS LIST**

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
8	D3503-1	CUP

RELEASED

06 04 25

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A	06.04.04	NEW ISSUE
DESIGN	DRAWN BY PH	DART DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA
CHECKED JAH	APPROVED	DRAWING NO. D3511
DATE 06.04.04	TITLE WEARPLATE	REV. A SHEET 1 OF 1 SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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